



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2646
Job Sheet 191060

DAS
21
9-09
48

Part No: D2646 Job Qty: 50 pcs
Part Name: Aft Cap

Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 2/21/19 Job Tracking No:
Due Date: 3/18/19 Created By: Marie Lajeunesse
Type: Stock Description:
Note: DWG REV C IPP: G 05.08.22 Hole size revised in Step 5 KJ/JLM IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Purchasing	50 pcs	3/18/19	3/18/19	0.00	0.00	Purchasing - 1			MAR 07 2019
							Purchasing - 2			
							Purchasing - 3			
110	Packaging 2-1 - Receive - B4B	50 pcs	3/18/19	3/18/19	0.00	0.00	Packaging 2 - 1 - B4B			MAR 07 2019
							Packaging 2 - 2 - B4B			
							Packaging 2 - 3 - B4B			
							Packaging 2 - 5 - B4B			
							Packaging 2 - 4 - B4B			
							Packaging 2 - 6 - B4B			
							Packaging 2 - 7 - B4B			
							Packaging 2 - 8 - B4B			
							Packaging 2 - 9 - B4B			
							Packaging 2 - 10 - B4B			
							Packaging 2 - 11 - B4B			
							Packaging 2 - 12 - B4B			
							Packaging 2 - 13 - B4B			
							Packaging 2 - 14 - B4B			
							Packaging 2 - 15 - B4B			
							Packaging 2 - 16 - B4B			
							Packaging 2 - 17 - B4B			
							Packaging 2 - 18 - B4B			
							Packaging 2 - 19 - B4B			
							Packaging 2 - 20 - B4B			
							Packaging 2 - 21 - B4B			
							Packaging 2 - 22 - B4B			
							Packaging 2 - 23 - B4B			
							Packaging 2 - 24 - B4B			
							Packaging 2 - 25 - B4B			
							Packaging 2 - 26 - B4B			
							Packaging 2 - 27 - B4B			

DART
AEROSPACE
Container No: S160607

Part: D2646
Job No: 191060
Serial No/Batch: S160607
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 03/07/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

P.T.O.

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
120 QC 6	50 pcs	3/18/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	DAS MAR 08 2019 68
				QC 6 - 61	DAS 9-89
130 Small Fab - 2 - B4B	50 pcs	3/18/19	0.00 2.01	Small Fab - 1 - B4B	DAS 58 MAR 11 2019 9-89
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
140 QC 5	50 pcs	3/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	MAR 12 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
150 Handfinish - 1-1 Chemical-B4B	50 pcs	3/18/19	0.00 1.78	QC 5 - 30	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/03/13
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 -	

				B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White Gl(A)- B4B	50 pcs	3/18/19	0.00 0.62	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	HL 19-3-15
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
180 Small Fab - 3 - B4B	50 pcs	3/18/19	0.00 2.01	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	HL 19-3-15
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
190 QC 5	50 pcs	3/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	

200	Packaging 3-1 - Stock - B4B	50 pcs	3/18/19	0.00 0.00	QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	FP-601 21 14-3-15
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
210	QC 21 - SA	50 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAS 21
					QC 21 - SA - 53	MAR 15 2019

Part Op 100 - (Purchasing) Issue P/O: _____ 1-Spin as per Dwg D2646 2-Material release note required Vendor:

Descriptions: Sleg's Manufacturing

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached

120 - (QC6- All purchased or subcontracted products)

130 - (Small Fab) 1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .297 as per Dwg D2646. 3-Deburr

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Small Fab) Install inserts as per Dwg D2646

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: FP-001) LOCATION : FP001

210 - (QC21- Final Inspection - Work Order Release)

009626

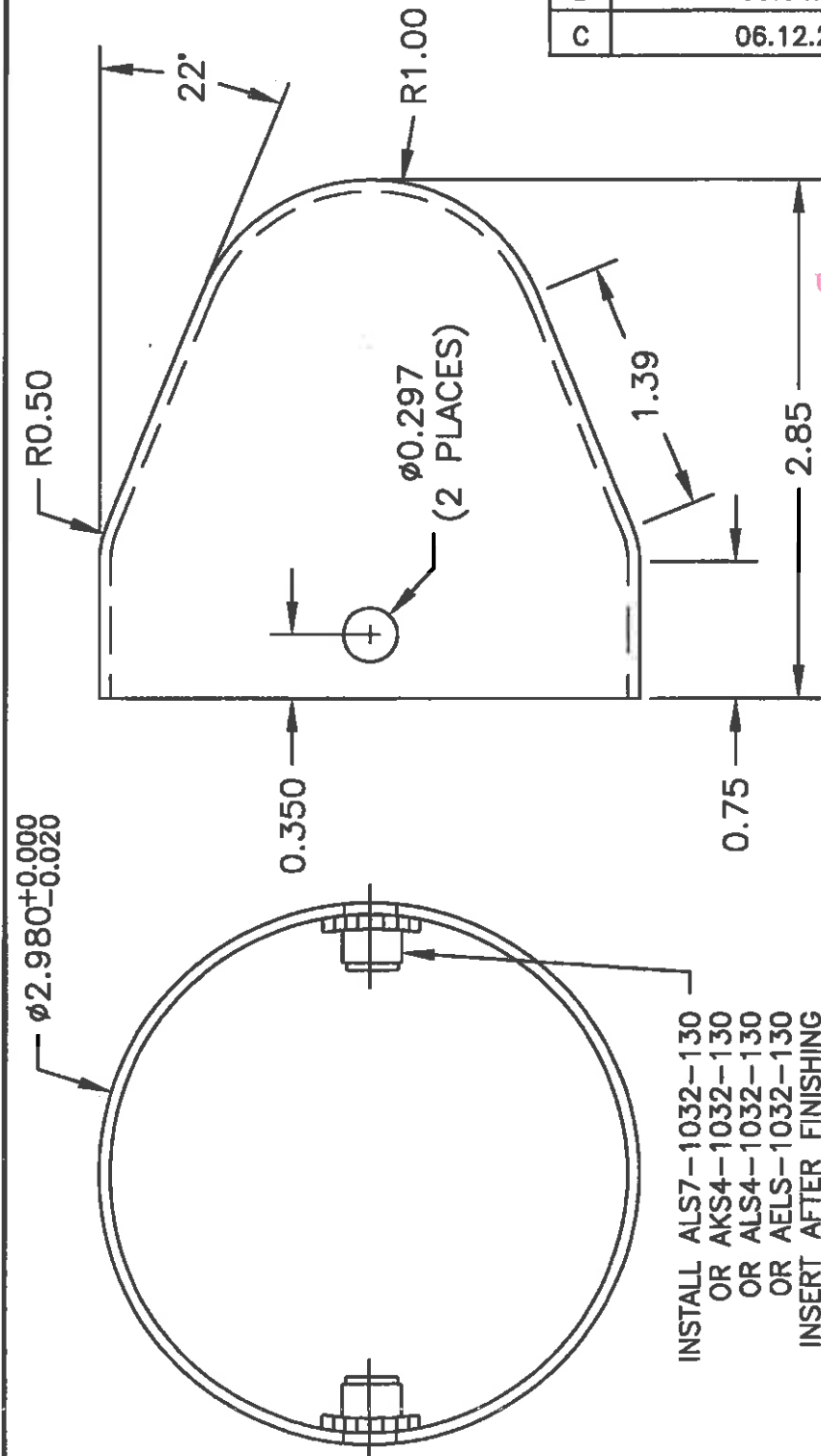
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
ALS7-1032-130	Rivnut	100 Ea (2 ea)	100-Purchasing	360606
D2646P	Aft Cap	50 pcs (1 ea)	180-Small Fab - 3 - B4B	135096

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	ALS7-1032-130	100	1,178	0
180-Small Fab - 3 - B4B	D2646P	50	0	0
Part Specifications				
Specifications could not be found.				

Plex 2/21/19 8:30 AM Dart.lajeunesse.marie



DESIGN DS		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2646	
DATE 06.12.20				REV. C SHEET 1 OF 1	
		TITLE AFT CAP		SCALE 1:1	
A	97.03.25		NEW ISSUE		
B	05.04.01		CHANGE TO CLOSED INSERTS		
C	06.12.20		CHANGE TO OPEN ENDED INSERTS		



RELEASED
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WITHOUT NOTICE
WORK ORDER
NO. 191060
MCS 19-02-2

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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md
18 July 2019

Job: 191060		DISPOSITION		DEPARTMENT/PROCESS			
Part No. D2646		Rework ☐ Scrap ☒ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☒ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐			
Date : MAR 15 2019		Sequence #: 170 QC3		QTY Affected : 2		MRB (QS1042) 19-03-15	
Description Work Order Deviation				Disposition			
-TWO PARTS WERE DROPPED, CHIPPING POWDER COAT BEYOND REPAIR.				-SCRAP			
Root Cause		FAULT CATEGORY					
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:		Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
				Completed By DAS 68 MAR 9 2019		Lead hand / Supervisor	
				QC / QA Coordinator DAS 68 9-89		MAR 15 2019	
				MAR 15 2019			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO042686



Supplier: SIE001-VC
Sieg's Manufacturing Ltd.
6236 - 205 Street
Langley
BC
V2Y 1N7 Canada
Phone: 604 530 7455
Fax: 604 530 7490

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042686
PO Date: 2/22/19
Due Date: 3/19/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

EMAILED
FEB 22 2019

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191060	D2646P			AFT CAP	Firmed	-	3/19/19	50 Ea	0 Ea	50 Ea	\$5.36/Ea	\$268.00
					AS PER DWG D2646 REV. C	50 X	MAR 07 2019						
Grand Total:													\$268.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 2/22/19 11:39 AM dart.lavoie.chantal



Sieg's Manufacturing Ltd.
6236 205 Street Langley, BC Canada V2Y 1N7
Ph:(604) 530-7455
Website: www.siegsmfmg.com

Packing Slip

Packing Slip No.: 1809
Date: 02/26/19
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Chantal Lavoie 1270 Aberdeen Street Hawkesbury, ON K6A 1K7	Dart Aerospace Ltd. Chantal Lavoie 1270 Aberdeen Street Hawkesbury, ON K6A 1K7
Order No.: PO042686 ✓	Sold By: Debbie Kaulbars
Shipped By: CANADA POST	Ship Date: 02/26/19
Tracking No.: 1644 8955 7903 4205	

Item No.	Unit	Description	Quantity
D2646P ✓	EACH	AFT CAP	✓ 50
Comment:			



6236 205 Street Langley, B.C. Canada V2Y 1N7
Ph#: (604)530-7455 info@siegsnmfg.com

INSPECTION REPORT

Date: February 26 2019
Customer: Dart Areospace
Packing Slip: 1809

Part#:	Quantity	Material	Check holes	Insp. By.
D2646P ✓	50 ✓	14g aluminum 1100-0	N/A	DK

Material Certification Attached: yes



111 Balsam Road
Shaboygan Falls, WI 53085

MILL TEST CERTIFICATE

We hereby certify that the material detailed below has been inspected & tested and conforms to the requirements of the specifications herein.

PAGE : Page 1 of 2
CERT NO : 18-1597
DATE : 12/18/2018

MATERIAL & SPECIFICATION					COUNTRY OF ORIGIN		REFERENCE NUMBER								
Aluminum Circles, Sheets					Hong Kong		A18121368								
ITEM	DESCRIPTION & SIZE	ALLOY & TEMPER	QTY. lb.	TAG NO	TENSILE Strength ksi UTS	EARING %	ELONG. %	CHEMICAL COMPOSITION %							
								Fe	Si	Min	Cu	Mg	Cr	Pb	Al (Bal.)
1	Aluminum Circles 0.051" x 8.500"	1100 0	2306	IP18025387	13.0		39.9	0.51	0.15						99.27
2	Aluminum Circles 0.051" x 14.000"	1100 0	3679	IP18024478 IP18024479	13.0 13.4	2.7 3.0	34.4 34.5	0.43 0.43	0.13 0.13						99.38 99.38
3	Aluminum Sheets 0.051" x 144.000" x 48.000"	1100 0	2967	CL18881245	13.1		39.7	0.43	0.13						99.37
4	Aluminum Circles 0.063" x 19.000"	1100 0	4700	IP18025345 IP18025363	13.5 13.5		34.2 37.2	0.45 0.45	0.15 0.15						99.32 99.32
5	Aluminum Circles 0.063" x 33.000"	1100 0	1874	IP18025023 IP18025024	13.0 13.0		38.1 38.1	0.5 0.5	0.16 0.16						99.27 99.27
6	Aluminum Sheets 0.063" x 120.000" x 36.000"	1100 0	2447	CL18881280	12.6		41.3	0.5	0.16						99.27
7	Aluminum Sheets 0.063" x 120.000" x 48.000"	1100 0	5395	CL18881225 CL18881226	13.1 13.0		40.4 38.2	0.43 0.43	0.13 0.13						99.37 99.37
8	Aluminum Circles 0.080" x 31.000"	1100 0	2224	IP18024905	12.5		42.4	0.44	0.15						99.35
9	Aluminum Circles 0.080" x 31.000"	1100 0	0	IP18024906	13.5		40.0	0.48	0.15						99.26
10	Aluminum Circles 0.090" x 42.000"	1100 0	2745	IP18024809 IP18025468	12.8 13.1		38.3 41.1	0.45 0.48	0.14 0.16						99.33 99.26

For Meyer Aluminum Blanks, Inc.

Anne Tinnon

2019-01-16

08:40:52

Quality Control

ISO 9001:2008

We hereby certify that the material detailed below has been inspected & tested and conforms to the requirements of the specifications herein.

MATERIAL & SPECIFICATION								COUNTRY OF ORIGIN		REFERENCE NUMBER					
Aluminium Circles, Sheets								Hong Kong		A18121368					
ITEM	DESCRIPTION & SIZE	ALLOY & TEMPER	QTY. lb.	TAG NO	TENSILE Strength ksi UTS	EARING %	ELONG. %	CHEMICAL COMPOSITION %							
								Fe	Si	Mn	Cu	Mg	Cr	Pb	Al (Bal.)
11	Aluminium Circles 0.125" x 37.500"	1100 0	3651	IP18024793 IP18024974 IP18024975	13.0 12.6 12.6		39.2 39.1 39.1	0.45 0.43 0.43	0.14 0.13 0.13						99.33 99.37 99.37
12	Aluminium Circles 0.074" x 25.750"	3002 0	875	IP18005467	12.6		36.1	0.075	0.034	0.12	0.085	0.1			99.52
13	Aluminium Circles 0.063" x 11.750"	3003 0	1814	IP18025521	16.1	3.4	35.8	0.64	0.24	1.08					97.90